

Claims

1. Apparatus for continuous vertical casting of metal strips, comprising
a mould (10) having top and bottom ends an open-ended mould cavity (C)
5 with a mould entrance opening (E) at the top end and a strip exit opening at the
bottom end,
a tundish (11) for holding molten metal, said tundish having a discharge
opening (11A) in direct communication with the mould cavity (C) to feed molten
metal into the mould entrance opening (E) past an interface between the
10 tundish (11) and the mould (10),
a sealing device (14) forming a seal at said tundish-mould interface to
prevent molten metal from entering said interface, and
a molten-metal feeding device (12) for supplying molten metal to the
tundish (11) and maintaining a level of molten metal therein,
15 **characterised** in that said sealing device (14) comprises
an upwardly facing horizontal flat sealing element support surface (10A)
on the mould (10) at the top end thereof, said sealing element support surface
(10A) extending about the mould entrance opening (E),
a flat downwardly facing surface (11B) on the tundish, said downwardly
20 facing surface (11B) extending about the discharge opening (11A) of the
tundish, and
a sealing element (14A) formed of a sheet of graphite and being in
constant sealing engagement with both said horizontal sealing element support
surface (10A) on the mould (10) and said downwardly facing surface (11B) of
25 the tundish (11), said sealing element (14A) extending about the mould
entrance opening (E) and the discharge opening (11A) of the tundish (11).
2. Apparatus according to claim 1, wherein the mould (10) comprises a pair
of side walls (15), each side wall comprises a vertical graphite block (17) formed
30 from a stack of elongate graphite laminae (20) and one end of said block forms
part of said sealing element support surface (10A) of the mould.

3. Apparatus according to claim 2, wherein the graphite laminae (20) of the stack extend from the entrance opening (E) of the mould cavity (C) to the exit opening and wherein said part of the sealing element support surface (10A) on the mould (10) is formed by the ends of the laminae.

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4. Apparatus according to claim 3, wherein a plurality of coolant tubes (19) extend horizontally through the graphite block (17) through apertures formed in the graphite laminae (20).

10 5. Apparatus according to any one of claims 1 to 4, wherein the mould (10) further comprises a pair of end walls (16) of graphite which bridge gaps between the side walls (15), said end walls having flat horizontal upper end faces which are level with said one end of each of said graphite blocks (17) and form parts of said sealing element support surface (10A) on the mould.

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6. Apparatus according to any one of claims 1 to 5, wherein said downwardly facing surface (11B) of the tundish (11) is slidable with respect to the sealing element (14).